

Work Order ID 99202

April-01-13 1:42:32 PM

99202

Page 1

Item ID: D2571

Revision ID:

Item Name: Saddle. Fwd Out 205

Start Date: 4/01/13

Start Qty: 8.00

8

Required Date: 4/19/13

Req'd Qty: 8.00

8

Reference:

Approvals:

Process Plan: *MLS*

Date: *13-04-01*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2571

F

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

13-04-08
13/04/04

12 *0*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *99202*

Double check by: *13*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect

110

0.00

110

CONVENTIONAL MILLING MACHINE

13-04-08
13/04/05

12 *0*

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

Work Order ID 99202

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99202

Page 2

Item ID: D2571

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle. Fwd Out 205

Start Date: 4/01/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 4/19/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

13/04/05
13-04-08

12

0

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

13.4 - P

12

0

DA
04
9-88

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

12 7/6 13-4-9

Work Order ID 99202

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Page 3

Item ID: D2571

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle. Fwd Out 205

Start Date: 4/01/13

Start Qty: 8.00

8

Cust Item ID:

Required Date: 4/19/13

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

12 8 X Y m / 13/04/09

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12 6 13-4-9

170

Identify as per dwg & Stock Location: ST44/ 0.00

170

Packaging

Memo

0.00

Packaging

12 x SP 13-4-10

Work Order ID 99202

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99202

Page 4

Item ID: D2571

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd Out 205

Start Date: 4/01/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 4/19/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

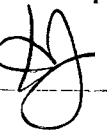
180

QC

Memo

0.00

Quality Control

13/4/11 

13-04-10

Picklist Print

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Page 1

Work Order ID: 99202

99202

Parent Item: D2571

D2571

Parent Item Name: Saddle. Fwd Out 205

Start Date: 4/01/13

Required Date: 4/19/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	30.0000	1	8			

D6101-007

Saddle Billet

**

Location	Loc Qty	Loc Code
MAT041	29	
85432	1	
88516	4	
89349	3	
90563	1	
92730	20	
MAT042	1	
85432	1	

95910 x 6

gmk 13/04/04

DART AEROSPACE LTD	Work Order:	99202
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.747	1.747		
C	3.495	3.505		3.500	3.500	3.497	3.496		
D	1.745	1.755		1.750	1.750	1.747	1.747		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.502	.5025		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.498	.498	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.565	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.132	.132	.131	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.237	.238	.238		
W	0.115	0.135		.122	.122	.120	.120		
X	0.308	0.313		.309	.309	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.364	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.247	.246	.247		
AE	1.375	1.395		1.388	1.388	1.389	1.389		
AF	0.115	0.135		.132	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.246	.247	.247	.247		
AI	2.000	2.020		2.000	2.001	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	13/04/04 / 13-04-06

Audited by:	<i>[Signature]</i>
Date:	13-4-8

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	99702
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	27	28		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.7465	1.747	1.748	1.748		
C	3.495	3.505		3.498	3.496	3.498	3.498		
D	1.745	1.755		1.7465	1.747	1.748	1.748		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.507	.507	.492	.493		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.498	.498	.498	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.5625	.563	.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.120	.122	.118	.117		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.966	2.960	2.960	2.960		
V	0.230	0.250		.236	.239	.238	.238		
W	0.115	0.135		.120	.119	.118	.118		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.370	.370	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.627	.627	.620		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.250	.243	.243		
AE	1.375	1.395		1.3907	1.3899	1.3905	1.3905		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.246	.251	.248		
AI	2.000	2.020		2.0056	2.0039	2.0048	2.0049		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	AMF / JH
Date:	13/04/05 / 13-04-07

Audited by:	DAS
Date:	13-4-8

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 99202
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.504	.502	.505	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.497	.501	.498	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.5625	.5645	.564	.564		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.502	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		.125	.124	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.119	.122	.121	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	.238	.238		
W	0.115	0.135		.119	.119	.119	.119		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.367	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.247	.246	.247		
AE	1.375	1.395		1.390	1.3904	1.3888	1.389		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.247	.247	.247		
AI	2.000	2.020		2.0039	2.0040	2.0028	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	<i>[Signature]</i>
Date:	13-04-07

Audited by:	<i>[Signature]</i>
Date:	13-4-8

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